



Dart Hawkesbury
1270 Aberdeen St
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K6A 1K7
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Tel (613) 632-5200

5002114

D119-796-251
Job Sheet 162955



Part No: D119-796-251

Job Qty: 1 ea

Part Name: Aft Crosstube Installation With Step (No Hardware)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG D119-796-251 REV E, IIN-D119-796 REV F IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP REV:B 14.10.15 AS PER REV.A DD VERF:JLM IPP REV:C 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:D 14.12.09 AS PER REV.PC6 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV D JLM VERF:DD

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D119-796-251 Aft Crosstube Installation With Step (No Hardware)	DWG D119-796-251 REV E, IIN-D119-796 REV F IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP REV:B 14.10.15 AS PER REV.A DD VERF:JLM IPP REV:C 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:D 14.12.09 AS PER REV.PC6 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV D JLM VERF:DD		0.000	
D119-796-241 Aft Crosstube Installation Without Step (No Hardware)	DWG REV J IPP REV:A 14.09.03 NEW ISSUE DD VERF:JLM IPP REV:B 14.10.15 AS PER REV.B DD VERF:JLM IPP REV:C 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:D 14.12.12 AS PER REV.pd1 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV F JLM VERIFIED BY:DD IPP REV:F 17.05.08 AS PER IIN REV.F DD VERF:JFS		0.000	
D5123-3 Clamp Cushion	DWG REV D IPP REV:A NEW ISSUE 14-08-28 JLM VERIFIED BY:DD IPP REV:B 16-11-11 AS PER DWG REV.D DD VERF:JLM		0.000	
D5149-043 Aft Step Base Assembly	DWG REV D SHEET 2 IPP REV:A 14.10.14 NEW ISSUE DD VERF:JLM IPP REV:A 14.12.15 dwg pb1 DD VERF:JLM		0.000	
MS21920-25 Clamp			0.000	

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/30/17	0.00	0.00	Start up container	
110	DC	1 pcs	10/30/17	0.00	0.00	DC	
120	Packaging	1 pcs	10/30/17	0.00	0.00	Packaging1	
130	Crosstubes	1 pcs	10/31/17	0.00	0.51	Crosstube	DAS
140	QC	1 pcs	10/31/17	0.00	0.00	QC5	38
150	Packaging	1 pcs	10/31/17	0.00	0.00	Packaging3	1.10.19-89
160	QC21-FG	1 Ea	10/31/17	0.00	0.00	QC21	

Part Op 110 - Photocopy bluefile and create labels as per PPP D119-796-251 chg 002

Descriptions: 130 - 1- Install step and clamp with the proper position per dwg D119-796-251 ***Torque all clamps to 50 IN-LBS max.***

140 - ***RE-CHECK TORCQUE ON CLAMP AS PER DWG.***

150 - Identify and pack for shipping as per PPP D119-796-251

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D119-796-241 5002114	1	0	0	0
	D5123-3 153233	4	0	0	0
	D5149-043 158121 (1X)	2	0	0	0
	MS21920-25 138336	4	0	0	0

DART
AEROSPACE
S002699

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Hawkesbury, ON K64 1K7
CANADA
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Email: sales@dartaero.com
www.dartaerospace.com



Aft Crosstube Installation With Step (No Hardware)

PART NO: D119-796-251
Revision:
Operation: Start up Operation
Quantity: 1
Change No:

Mfg Date: 10/26/17 Job No: 162955
--

Part Specifications
Specifications could not be found.

Plex 10/2/17 1:40 PM Dart.lajeunesse.marie

Work Order ID 162955

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162955

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Item ID: D119-796-251

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 6/20/2017 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/17/2017 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: ^{DAS} ₂₁ ₃₋₈₉ Date: JUN 19 2017

Tooling:

Date:

Run Start

NR1

QC: Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D119-796-251	E
IIN-D119-796	F

110 Document Control 0.00

110

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels as per PPP D119-796-251 Chg 004

120 Pick Kit 0.00

120

Packaging

Memo

0.00

Packaging

Work Order ID 162955

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162955

Page 2

Item ID: D119-796-251

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 6/20/2017 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/17/2017 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Crosstubes

Crosstubes

Memo

0.46

Crosstubes

1- Install step and clamp with the proper position per dwg D119-796-251

Torque all clamps to 50 IN-LBS max.

140

QC5- Inspect part completeness to step on W/O 0.00

140

QC

Memo

0.02

Quality Control

RE-CHECK TORCQUE ON CLAMP AS PER DWG.

***VERIFY BY _____ BATCH # TO MATCH W/O

***VERIFY BY _____ PART # TO MATCH

W/O _____

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Item ID: D119-796-251

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 6/20/2017 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/17/2017 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
143	Pick Kit	0.00							
143									
Packaging	Memo	0.00							
Packaging									
146	QC4- 100% Inspect kits for completeness	0.00							
146									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Packaging								
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP D119-796-251								

Work Order ID 162955

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Item ID: D119-796-251**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop *NS2*****Item Name:** AFT Crosstube Installation with Step (no hardware)**Start Date:** 6/20/2017 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 7/17/2017 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start*****NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.10

Quality Control

Picklist Print

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Work Order ID: 162955

162955

Parent Item: D119-796-251

D119-796-251

Parent Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 6/20/2017

Required Date: 7/17/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP REV:B
14.10.15 AS PER REV.A DD VERF:JLM IPP REV:C 14.11.19
AS PER REV.C DD VERF:JLM IPP REV:D 14.12.09 AS PER
REV.PC6 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV D
JLM VERF:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN174-3A		Purchased	No			143	Each	22.0000	2	2			
AN174-3A									**				
BOLT													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST332				22					
				M132540				22					
MS21042-4	MS21042L4	Purchased	No			143	Each	2.0000	2	2			
MS21042-4									**				
Nut													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST304				2					
				9063				2					
NAS1149D0432J		Purchased	No			143	Each	1,099.000	4	4			
NAS1149D0432.J									**				
WASHER													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				24					
				m131026				24					
				ST260a				1000					
				m137459				1000					
				ST264				75					
				m134676				75					

Picklist Print

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Work Order ID: 162955

162955

Parent Item: D119-796-251

D119-796-251

Parent Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 6/20/2017

Required Date: 7/17/2017

Start Qty: 1.00

Required Qty: 1.00

D119-796-241

Manufactured No

120

Each

0.0000

1

1

D119-796-241

AFT Crosstube Installation without Step (no hardware)

D5123-3

Manufactured No

120

Each

578.0000

4

4

D5123-3

Clamp Cushion

Location

Loc Qty

Loc Code

LG052

200

160079

200

LG054

378

153233

378

D5149-043

Manufactured No

120

Each

17.0000

2

2

D5149-043

Aft Step Base Assembly

Location

Loc Qty

Loc Code

LG055

17

152435

3

158121

10

162694

4

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Shop Packet Print

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Picklist Print

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Work Order ID: 162955

162955

Parent Item: D119-796-251

D119-796-251

Parent Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 6/20/2017

Required Date: 7/17/2017

Start Qty: 1.00

Required Qty: 1.00

MS21920-25

Purchased

No

120

Each

119.0000

4

4

MS21920-25

Clamp

Location

Loc Qty

Loc Code

FG

4

120920

2

m134987

2

LG050

115

m136621

1

m136648

25

m137361

14

m137459

25

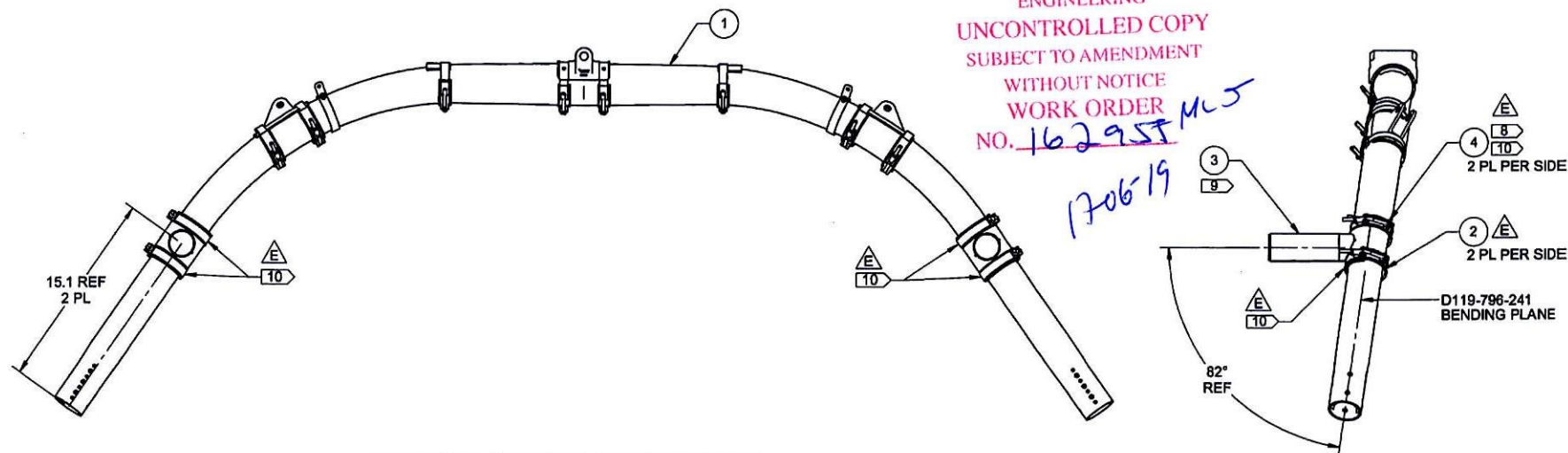
m137587

25

m137820

25

ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
1	1	D119-796-241	XTUBE ASSY (AW119 MKII AFT)
2	4	D5123-3	CUSHION
3	2	D5149-043	AFT STEP ASSY
4	4	MS21920-25	CLAMP



D119-796-251 XTUBE ASSY (AW119 MKII AFT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 29.9 lbs
- 8) TORQUE MS21920-25 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE
- 10) POSITION MS21920 CLAMPS SECURING THE STEPS AS SHOWN. THE THREADED PORTION OF THE CLAMP MUST FACE THE SAME DIRECTION AS THE STEP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162957
170619

E	MODIFY CLAMP ORIENTATION, ADD NOTE 10, REMOVED SECTION A-A (PAR16-527)	ML	17.02.10
D	D5123-3 WAS D5123-9, MS21920-25 WAS -26, ADDED SECTION A-A	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D2274 RADIUS BLOCK WAS D5153-1, AN4C12A WAS AN4C10A	AP	14.10.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	NO	DRAWING NO.	REV. E
MFG. APPR.	DD	D119-796-251	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII AFT)	NTS
DATE	17.02.10	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED, REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2017-05-04
ECN17-538

APPROVED